

NEED MONDAY

Work Order ID 83639

April-20-12 1:45:12 PM

83639

Page 1

Item ID: D4093-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 4/20/12 Start Qty: 8.00

8

Cust Item ID:

Required Date: 4/23/12 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4093

C

0.00

110

Waterjet

0.00

FLOW CNC Waterjet

Memo

CUT AS DWG

DWG REV: C

PROG REV: C

DEBURR

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

12-4-21

8

12-4-21

770 →

| W/O: 83639 | | WORK ORDER CHANGES | | | | | |
|------------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D4093-3 PAR #: _____ Fault Category: Small FAB/water Jet NCR: Yes No DQA Full Date: 12/04/27
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 12/4/27

| NCR: 12-1380 | | WORK ORDER NON-CONFORMANCE (NCR) 71.10 x 8 = 213.30 | | | | | | |
|--------------|------|--|-----------------------------|--|----------------|---------------------------|-------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 12/04/24 | #110 | Found at inspection that the parts were not satisfactory. Large markings from water jet cutting too fast + poor building | W 12/04/24 AS1042 | Scrap + destroy QH & E (AID). Replace M-121380 Jm/12-4-24 | | J 12/04/25 | W 12/04/24 AS1042 | J 12/04/24 |
| | | on parts with improper building parts. RL LOA + operator error reflect qty all = 8 | | | | | | J 12/04/24 |
| | | | | | | | | |

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 4/23/12 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

~~12-4-24~~

8

8

Quality Control

132

0.00

132

Small Fab

Memo

0.00

~~12-4-24~~

8

8

Small Fab

DRILL AS PER DWG

135

QC5- Inspect part completeness to step on W/O

0.00

135

QC

Memo

0.00

5/2/12/25

(88)

Quality Control

Work Order ID 83639

April-20-12 1:45:12 PM

83639

Page 3

Item ID: D4093-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 4/20/12 Start Qty: 8.00

8

Cust Item ID:

Required Date: 4/23/12 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

(8) 2/6 12-4-25

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

8 0 12-4-25

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

Amber
ST135A

10/2/12/25 (8)

Work Order ID 83639

April-20-12 1:45:12 PM

83639

Page 4

Item ID: D4093-3

Revision ID:

Item Name: Bracket

Start Date: 4/20/12 Start Qty: 8.00

Required Date: 4/23/12 Req'd Qty: 8.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00



Quality Control

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

12/4/25 
12-04-26

Picklist Print

April-20-12 1:45:12 PM

Page 1

Work Order ID: 83639
Parent Item: D4093-3
Parent Item Name: Bracket

Start Date: 4/20/12
Start Qty: 8.00

Required Date: 4/23/12
Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 10-10-04 JLM VERIFIED BY:DD
598 11-06-05 JLM VERIFIED BY:DD
IPP REV:B AS PER REV C 11.09.28 JLM VERIFIED BY:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.750X06.000 6061T6 BAR .750 X 6.00 | | Purchased | No | | | | f | 48.6600 | | 8 | | | |

1312-421

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT003 | 0.66 | |
| 120866 | 0.66 | |
| MAT004 | 48 | |
| 121380 | 48 | |

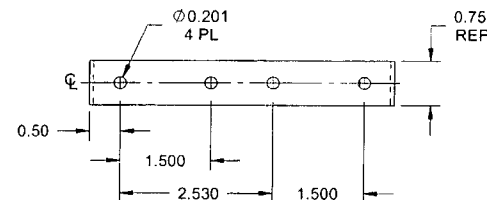
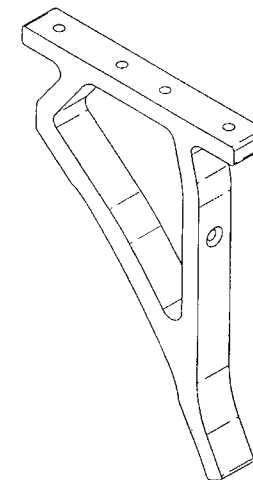
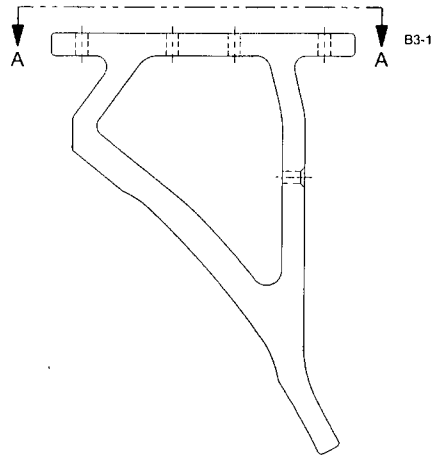
119231

Replace w/

121380.

119231

mk/jm
12-4-24



SECTION VIEW A-A D6-1

W/O 83639

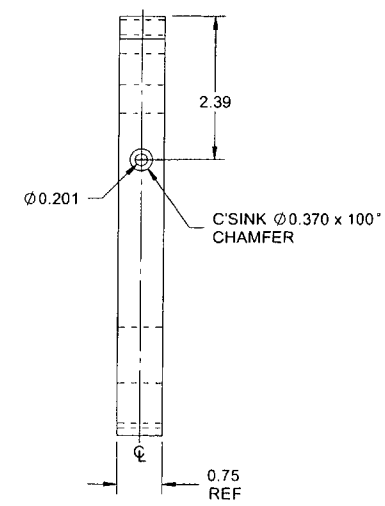
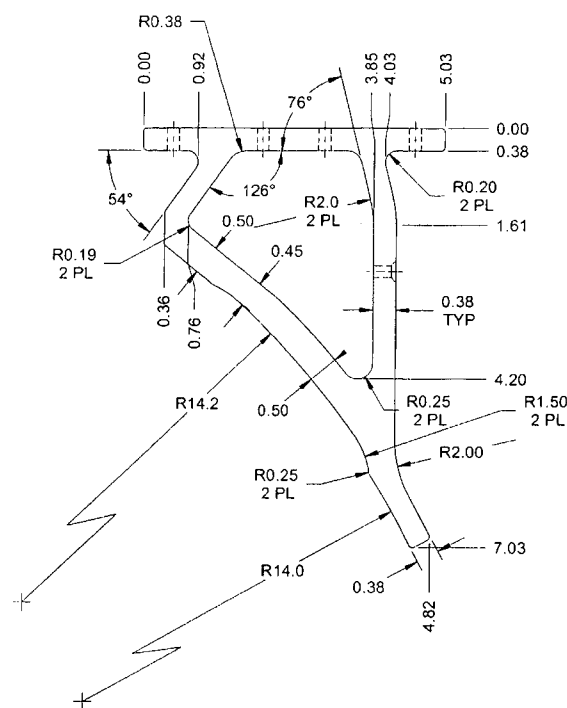
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.54 lbs

D4093-1 BRACKET

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2011-09-22

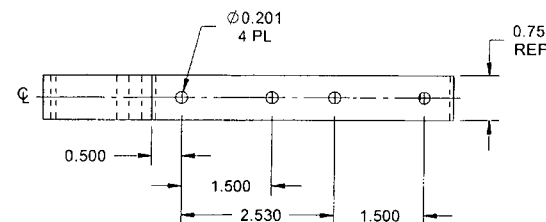
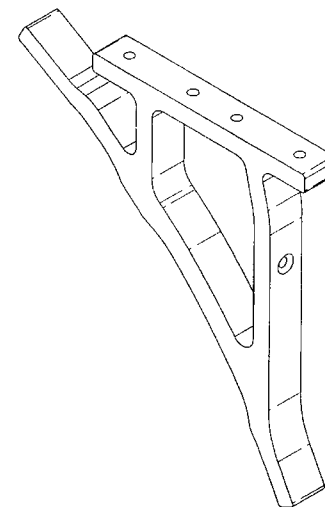
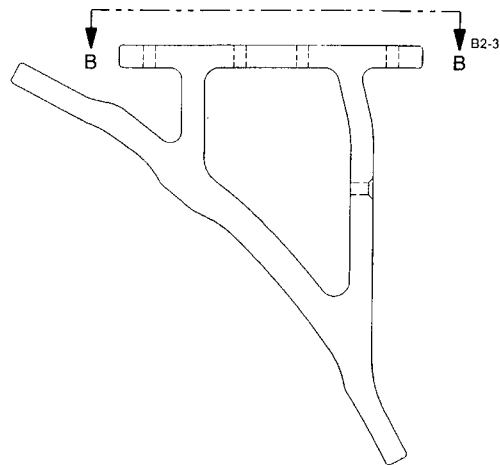
| C | REDRAWN D4093-1A-3 (ZN B4-1, B4-2); ADD MATERIAL NOTES (ZN A8-1, A8-3, A8-5) | RF | 11.07.27 |
|------------|--|---|--------------|
| B | REDRAWN D4093-1A-3 (ZN B4-1, B4-2) | RF | 11.01.31 |
| A | NEW ISSUE | RF | 10.09.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE USA, INC. KENT, WA | |
| DRAWN | RF | | |
| CHECKED | <i>MP</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>MP</i> | D4093 | SHEET 1 OF 5 |
| APPROVED | <i>MP</i> | TITLE | SCALE |
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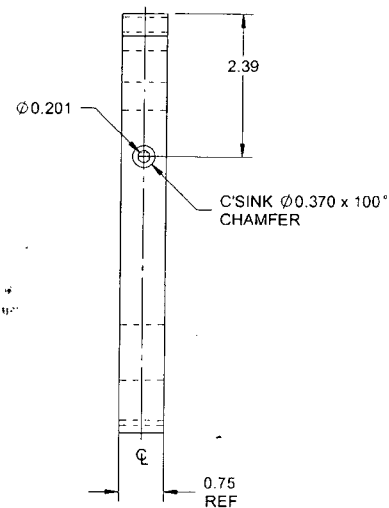
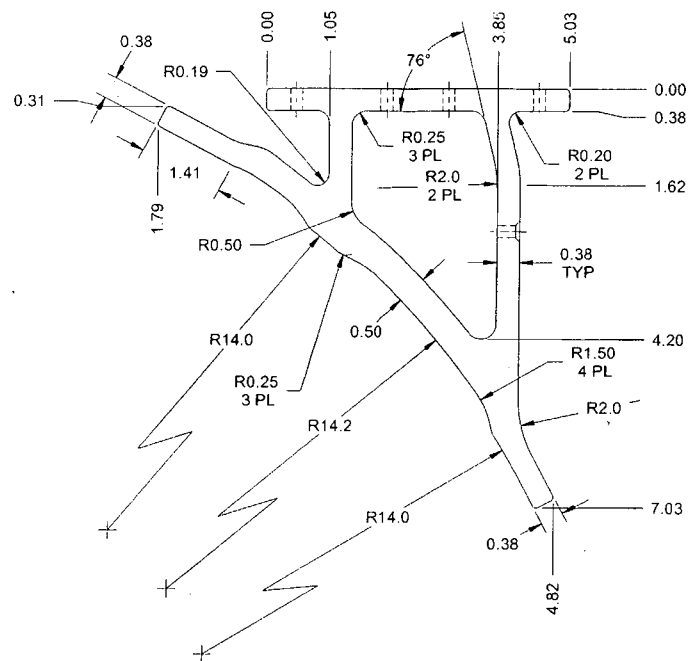
SECTION VIEW B-B B5-3

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

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MD

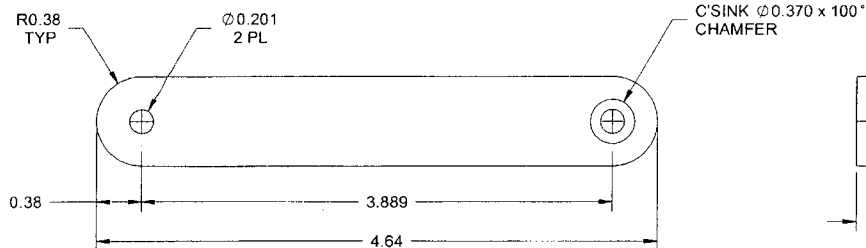
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| DRAWN | RF | KENT, WA | |
| CHECKED | <i>RF</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>RF</i> | D4093 | SHEET 3 OF 5 |
| APPROVED | <i>RF</i> | TITLE | SCALE |
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| MFG. APPR. | <i>21</i> | D4093 | SHEET 4 OF 5 |
| APPROVED | <i>140</i> | TITLE | SCALE |
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D4093-5 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
- REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

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| MFG. APPR. | <i>RF</i> | D4093 | SHEET 5 OF 5 |
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